

Work Order ID 145188

145188

Page 1

Wednesday, May 04, 2016 9:49:53 AM

Item ID: D4292-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fitting
 Start Date: 5/9/2016 Start Qty: 400 ***4*** Cust Item ID:
 Required Date: 5/19/2016 Req'd Qty: 400 ***4*** Customer:
 Reference:

Approvals: Process Plan: Em ZH Date: 16/05/04 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4292	C

100	BAND SAW	0.00							DAS 08 9-85
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blank to 6.250"								
****GRAIN DIRECTION MUST BE ALONG 4.00"*****									

110	HAAS CNC VERTICAL MACHINING #1	1.06							DAS 08 9-85
110									
HAAS 1	Memo	3.84							
HAAS CNC vertical machine #1	1-Machine per folio FB002								
	DWG REV: <u>C</u>								
	FOLIO REV: <u>AA</u>								
2- deburr rough edges									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																						OTHER :																																									

Work Order ID 145188

145188

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Wednesday, May 04, 2016 9:49:53 AM

Item ID: D4292-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fitting
 Start Date: 5/9/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/19/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.08				12	0		DAS 33 9-89 <i>11/16/06/08</i>
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.20							<i>12 x 4 11/16/06/13</i>
145 *145* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>17 13/16/15.</i> MASK THREADED HOLE	0.00 0.40							<i>START: 11:15. OV. T: 320° FINISH: 11:45.</i> <i>12 1/16/06/15. 33</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval							
Root Cause		FAULT CATEGORY													
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐				Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐				Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER : _____													

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Work Order ID 145188

Wednesday, May 04, 2016 9:49:53 AM

145188

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Item ID: D4292-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fitting

Start Date: 5/9/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/19/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

Identify as per dwg & Stock Location: St 53

0.00

180

Packaging

Memo

0.04

Packaging

JUN 22 2016

D46
6
9-88

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.40

Quality Control

MCS JUN 22 2016

MCS JUN 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

Wednesday, May 04, 2016 9:50:03 AM

Page 1

Work Order ID: 145188

145188

Parent Item: D4292-1

D4292-1

Parent Item Name: Fitting

Start Date: 5/9/2016

Required Date: 5/19/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-14 JLM VERIFIED BY:DD IPP REV
B: AS PER REV B 11-02-15 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B4.000x4.00 0		Purchased	No			100	f	25.5830	0.52	2.189474			

M7075T73B4 000x4 000

7075-T73 Bar 4.0 x 4.0

**

B. 16/06/04

Location

Loc Qty

Loc Code

MAT006

13.583

→ M132453

13.583

WEJAY

12

M116324

4

M126198

4

M126406

4

6.425 ft

MS21209F1-10

Purchased

No

Each

68.0000

4

MS21209F1-10

HELI COIL

**

16/06/21

DAS
36
9-89

Location

Loc Qty

Loc Code

ST297

68

m131139

18

m132344

50

12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

DART AEROSPACE LTD	Work Order:	145188
Description: Fitting	Part Number:	D4292-1
Inspection Dwg: D4292	Rev: C	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.063	+/-0.010	R0.063	✓		R-6	ref.
0.250	+0.030/-0.010	0.260	✓		Mic	GA-03
0.125	+0.030/-0.010	0.135	✓		"	"
2.95	+/-0.030	2.958	✓		Vern	GA-13
0.275	+/-0.010	0.278	✓		"	"
0.800	+/-0.010	0.798	✓		"	"
0.825	+/-0.010	0.823	✓		"	"
0.375	+/-0.010	0.377	✓		"	"
0.31	+/-0.030	0.315	✓		"	"
0.88	+/-0.030	0.887	✓		"	"
0.663	+/-0.010	0.6625	✓		"	"
Ø0.381	+0.000/-0.001	0.381	✓		Mic/T-6	GA-03 / ref.
1.125	+/-0.010	1.125	✓		Vern	GA-13
1.063	+/-0.010	1.083	✓		"	"
3.44	+/-0.030	3.434	✓		Vern	GA-13
2.450	+/-0.010	2.450	✓		"	"
1.325	+/-0.010	1.327	✓		Mic	GA-02
0.300	+/-0.010	0.302	✓		Mic	118-120
1.200	+/-0.010	1.200	✓		Vern	GA-13
2.84	+/-0.030	2.836	✓		H-6	31006
0.19	+/-0.030	0.190	✓		Vern	GA-13
5.86	+/-0.030	5.859	✓		H-6	31006
5.99	+/-0.030	5.990	✓		Vern	GA-13
Ø0.272	+0.006/-0.001	Ø0.272	✓		"	"
Ø0.266	+0.006/-0.001	Ø0.266	✓		"	"
1.75	+/-0.030	1.750	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-6	ref.
R0.06	+/-0.030	R0.063	✓		"	"
4.875	+/-0.010	4.875	✓		Vern	GA-13
0.493	+/-0.010	0.492	✓		"	"
C-bore Ø0.765	+/-0.010	Ø0.767	✓		"	"
0.250	+0.030/-0.010	0.259	✓		Mic	GA-03
0.680	+/-0.010	0.680	✓		Vern	GA-13
2.250	+/-0.010	2.250	✓		H-6	31006
4.500	+/-0.010	4.500	✓		Vern	GA-13
R1.275	+/-0.010	R1.275	✓		R-6	ref.
R0.031	+/-0.010	R0.032	✓		"	"

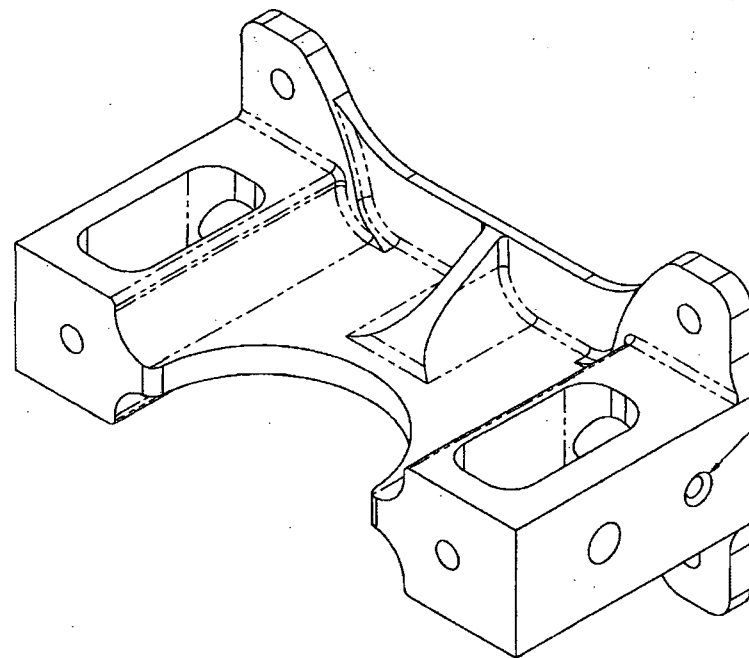
DART AEROSPACE LTD		Work Order:	
Description: Fitting		Part Number:	D4292-1
Inspection Dwg: D4292 Rev: C		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.13	+/-0.030	R0.125	✓		R-6	ref.
1.65	+/-0.030	1.661	✓		H-6	31006
1.421	+/-0.010	1.430	✓		"	"

Measured by: <u>A.P.</u> DAS Date: <u>16/06/04</u> 08 9-89	Audited by: <u>33</u> DAS Date: <u>16/06/08</u> 9-89	Preliminary Approval: Date:
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Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	<u>AA</u>



MS21209F1-10 HELICAL COIL, 1X
REF

GRAIN
DIRECTION

D4292-1 FITTING

RELEASED
2011-02-01

NOTES:

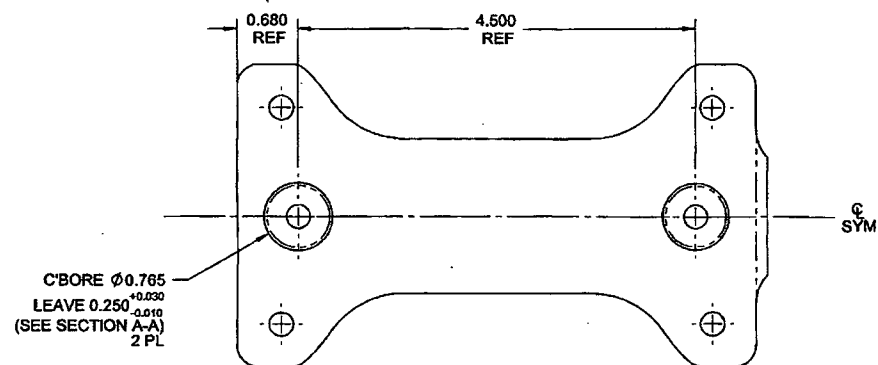
- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4292-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.02 lbs

C	1.084 WAS 1.235 (C1-2), Ø0.268 WAS Ø0.323 (B3-2), ADD HELICAL COIL (D1-2)	CP	10.12.23
B	0.800 WAS 0.78 (C6-2), 0.825 WAS 0.81 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4292	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FITTING (206L/407 FWD)	NTS
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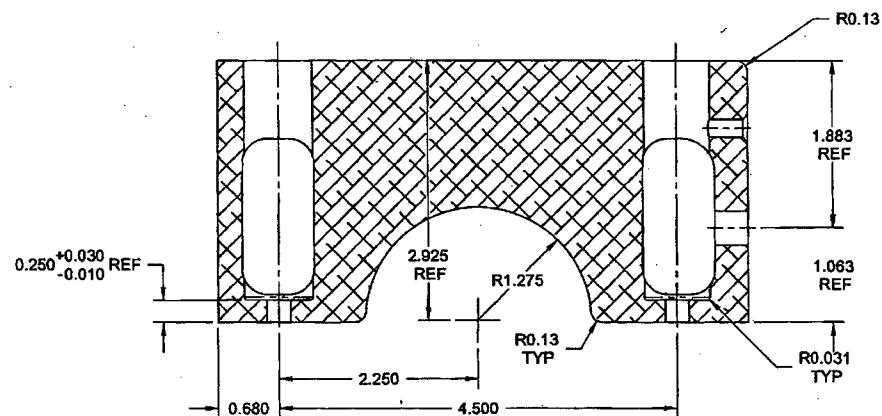
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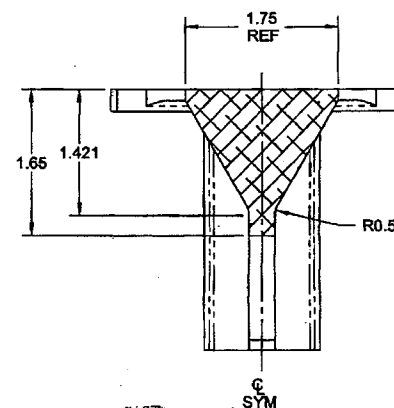
8 7 6 5 4 3 2 1



VIEW C-C D3-2



SECTION A-A A3-2



SECTION B-B C4-2

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2011-02-01

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4292	REV. C
MFG. APPR.		TITLE FITTING (206L/407 FWD)	SHEET 3 OF 3
APPROVED		SCALE	NTS
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